

Date: Wednesday, 5/23/2007 3:05:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET LH
Job Number : 32428	
Estimate Number : 12339	
P.O. Number : <i>N/A</i>	Part Number : D20133
This Issue : 5/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 26343	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>10</i> Um: Each
Comment : Est Rev. A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 2.0447 f(s)/Unit Total: 10.2233 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: *M104727*

FF 07-06-19 10

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per template D2013-T3 and Dwg D2013

FF 07-06-19 10

2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545

FF 07-06-19 10

3-Bend (1) tube as per Dwg D2013 using Jig DT8201
 Identify as D2013-3.

FF 07-06-20 10

4-Deburr as required

FF 07-06-19 10

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 PACKAGING 1 PACKAGING RESOURCE #1




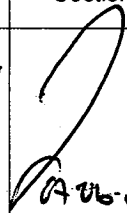
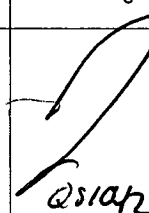

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: *N/A*

FC 07/06/25 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-21	2.0	bracket 1 Ann Scrap. Middle band was crooked causing the D2037-101 to not line up with the D2013-4. bracket. P.C. Human error.	 QSIWZ	Scrap: replace.	FF 07-06-21	 07-06-21	 QSIWZ	 07-06-21

NOTE: Date & initial all entries

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Drawing Name: MIRROR BRACKET LH

Job Number: 32428

Part Number: D20133

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

20710426

Job Completion



11 07.06.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

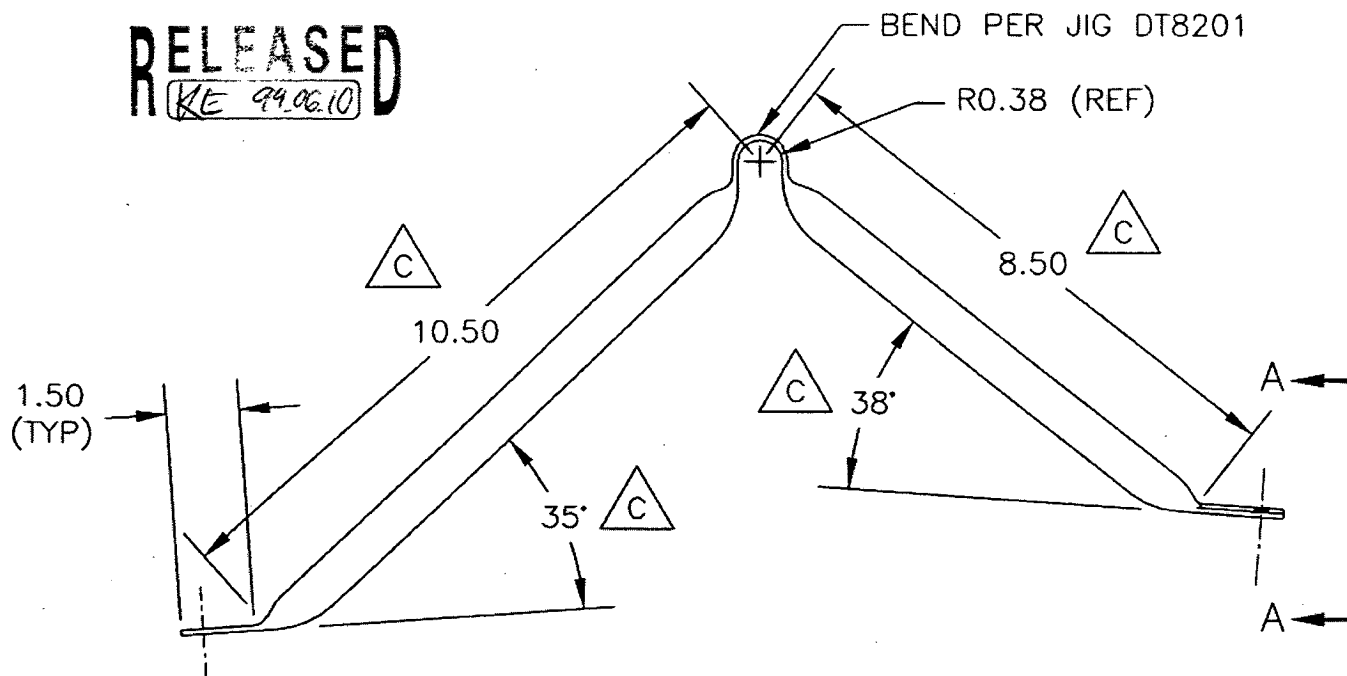
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

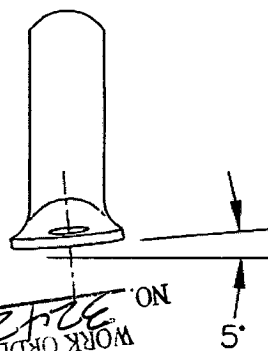
NOTE: Date & initial all entries

RELEASED
 KE 94.06.10

DART



D2013-1 LH SHOWN
 D2013-2 RH OPPOSITE
 (FOR 205 MIRROR)



DRILL $\phi 0.257$ (TYP)
 0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 OD x 0.049 WALL

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
JB.	RF	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2013
DATE 99.06.07		TITLE MIRROR BRACKET
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
		REV. C
		SHEET 1 OF 3
		SCALE NTS

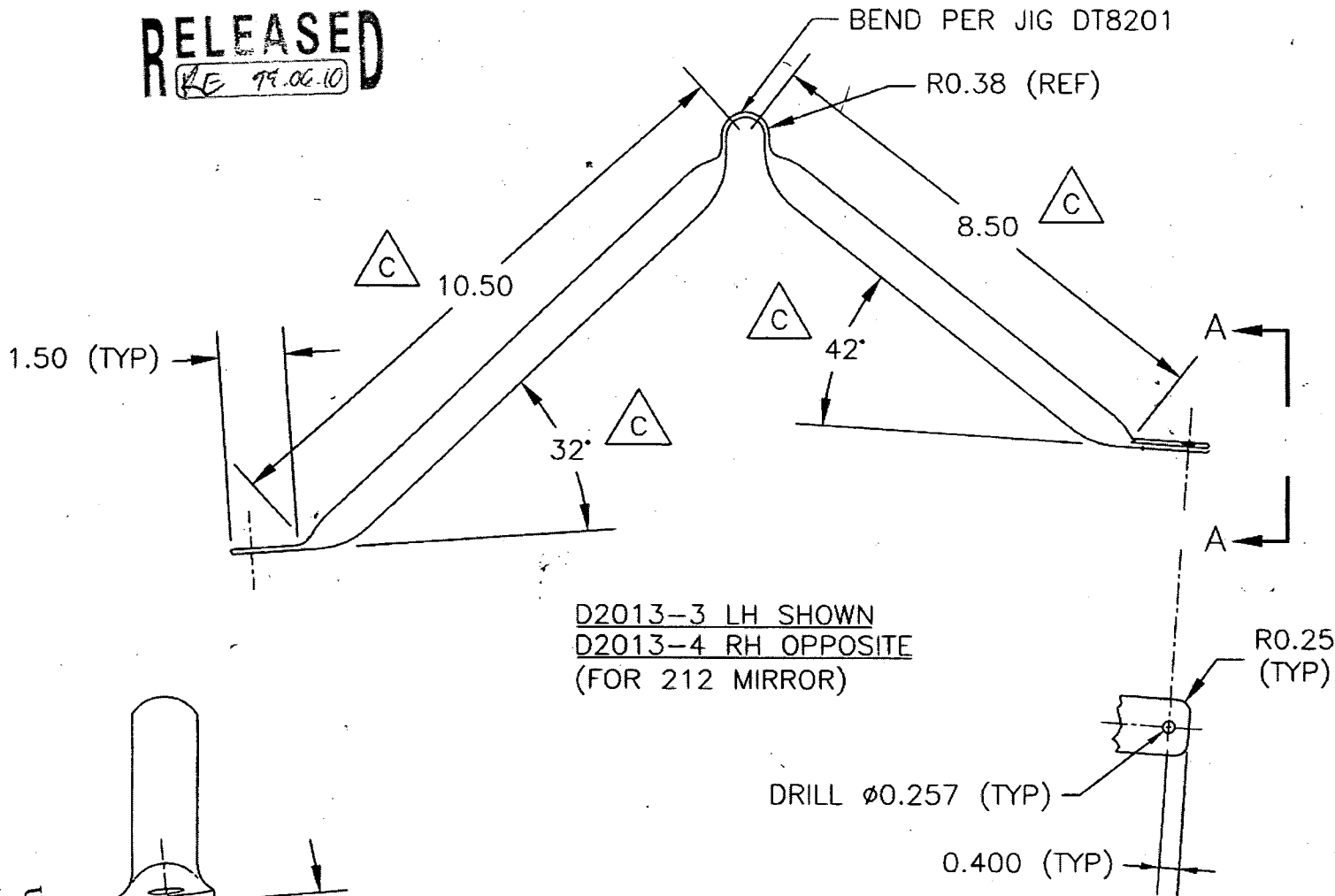
NO. 32428
 WORK ORDER
 A-111111
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RELEASED
RE 79.06.10

DART

QA CONTROLLED

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CHECKED	KE	APPROVED	RF	
DATE	99.06.07	DRAWING NO.	D2013	
TITLE	MIRROR BRACKET	SHEET 2 OF 3	REV. C	
SCALE	NTS			



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WORK ORDER
NO. 22428

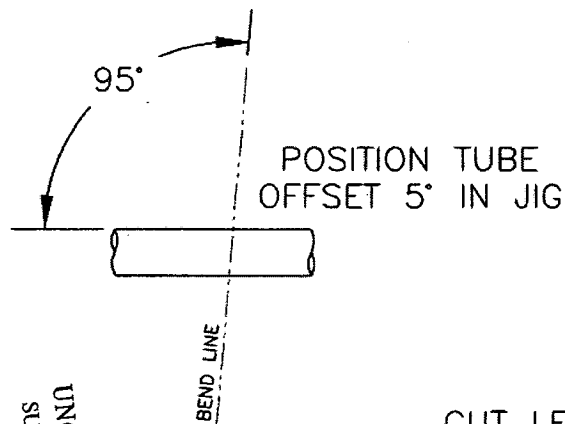
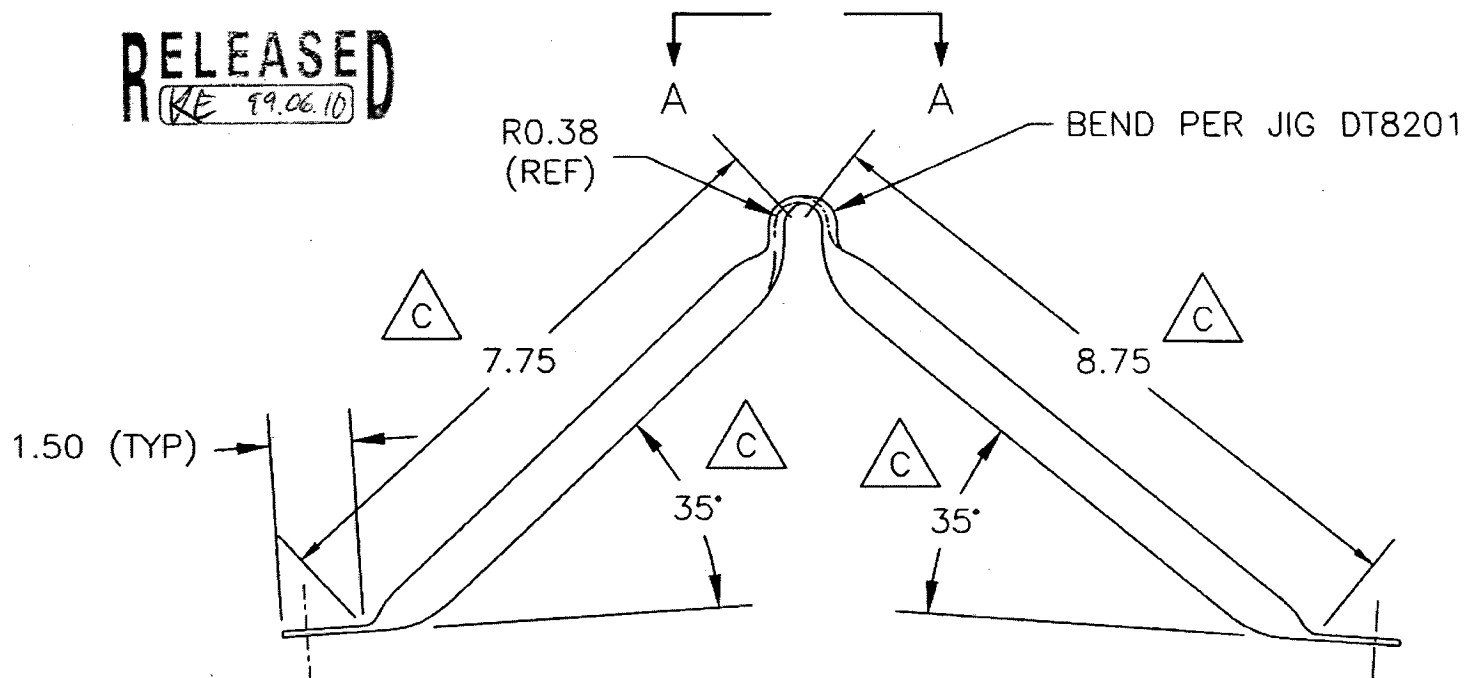
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(KE 99.06.10)

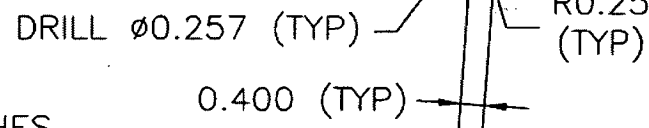
DART

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CHECKED	KE	APPROVED	RE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

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NO. 32428